

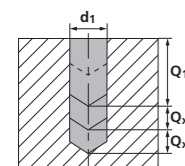
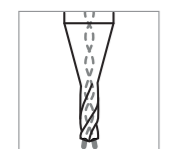
# CrazyDrill Cool XL 40 x d

RACCOMANDAZIONI PER L'USO

● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ⊗ Non consigliato



## FORARE CON RAFFREDDAMENTO INTERNO | VISTA D'INSIEME DEI DATI DI TAGLIO



| Gruppo materiali  | Materiale  | Mat. no.           | DIN                     | AISI/ASTM/UNS         | v <sub>c</sub><br>[m/min] | Q <sub>1</sub> | Q <sub>2</sub> | f [mm/giro] |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|---|--|--------------------|-------------------------|-----------------------|---------------------------|----------------|----------------|-------------|-------------------|------------------|-------------------|---------------------------|-----------------------|-------|-------|---|-------|-------|-------|-------|-------|-------|
|   |  |                    |                         |                       |                           |                |                | 2.0 mm<br>f | 2.5 mm<br>3/32" f | 3.0 mm<br>1/8" f | 4.0 mm<br>5/32" f | 5.0 mm<br>3/16" - 7/32" f | 6.0 mm<br>f           |       |       |   |       |       |       |       |       |       |
| P   | Acciai non legati<br>Rm < 800 N/mm <sup>2</sup>        | 1.0301             | C10                     | AISI 1010             | 50-100                    | 40xd1          | -              | 0.060       | 0.080             | 0.090            | 0.120             | 0.140                     | 0.160                 |       |       |   |       |       |       |       |       |       |
|   |  | 1.0401             | C15                     | AISI 1015             |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 1.1191             | C45E/CK45               | AISI 1045             |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 1.0044             | S275JR                  | AISI 1020             |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 1.0715             | 11SMn30                 | AISI 1215             |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 1.5752             | 15NiCr13                | ASTM 3415 / AISI 3310 |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   | Acciai debolmente legati<br>Rm > 900 N/mm <sup>2</sup> | 1.7131             | 16MnCr5                 | AISI 5115             | 50-100                    | 40xd1          | -              | 0.060       | 0.080             | 0.090            | 0.120             | 0.140                     | 0.160                 |       |       |   |       |       |       |       |       |       |
|   |  | 1.3505             | 100Cr6                  | AISI 52100            |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 1.7225             | 42CrMo4                 | AISI 4140             |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 1.2842             | 90MnCrV8                | AISI O2               |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 1.2379             | X153CrMoV12             | AISI D2               |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 1.2436             | X210CrW12               | AISI D4/D6            |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| Acciai da utensili fortemente legati<br>Rm < 1200 N/mm <sup>2</sup> | 1.3343   | HS6-5-2C           | AISI M2 / UNS T11302    | 40-80                 | 40xd1                     | -              | 0.050          | 0.060       | 0.075             | 0.100            | 0.120             | 0.150                     |                       |       |       |   |       |       |       |       |       |       |
|   | 1.3355   | HS18-0-1           | AISI T1 / UNS T12001    |                       |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   | Acciai inossidabili ferritici                          | 1.4016             | X6Cr17                  |                       |                           |                |                |             |                   |                  |                   |                           | AISI 430 / UNS S43000 | 30-60 | 40xd1 | - | 0.060 | 0.070 | 0.100 | 0.120 | 0.150 | 0.180 |
|   |  | 1.4105             | X6CrMoS17               |                       |                           |                |                |             |                   |                  |                   |                           | AISI 430F             |       |       |   |       |       |       |       |       |       |
|   |  | 1.4034             | X46Cr13                 |                       |                           |                |                |             |                   |                  |                   |                           | AISI 420C             |       |       |   |       |       |       |       |       |       |
|   | Acciai inossidabili martensitici                       | 1.4112             | X90CrMoV18              |                       |                           |                |                |             |                   |                  |                   |                           | AISI 440B             | 40-80 | 40xd1 | - | 0.100 | 0.120 | 0.150 | 0.180 | 0.200 | 0.220 |
| 1.4542  |  | X5CrNiCuNb 16-4    | AISI 630 / ASTM 17-4 PH |                       |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| Acciai inossidabili martensitici - PH                               | 1.4545   | X5CrNiCuNb 15-5    | ASTM 15-5 PH            | 30-60                 | 5xd1                      | 2xd1           | 0.060          | 0.070       | 0.100             | 0.120            | 0.150             | 0.180                     |                       |       |       |   |       |       |       |       |       |       |
|   | 1.4301   | X5CrNi 18-10       | AISI 304                |                       |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| Acciai inossidabili austenitici                                     | 1.4435   | X2CrNiMo 18-14-3   | AISI 316L               | 30-60                 | 5xd1                      | 2xd1           | 0.060          | 0.070       | 0.100             | 0.120            | 0.150             | 0.180                     |                       |       |       |   |       |       |       |       |       |       |
|   | 1.4441   | X2CrNiMo 18-15-3   | AISI 316LM              |                       |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   | 1.4539   | X1NiCrMoCu 25-20-5 | AISI 904L               |                       |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| K   | Ghise  | 0.6020             | GG20                    | ASTM 30               | 100-200                   | 40xd1          | -              | 0.080       | 0.100             | 0.120            | 0.160             | 0.200                     | 0.240                 |       |       |   |       |       |       |       |       |       |
|   |  | 0.6030             | GG30                    | ASTM 40B              |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 0.7040             | GGG40                   | ASTM 60-40-18         |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 0.7060             | GGG60                   | ASTM 80-60-03         |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| N   | Leghe d'alluminio battute                              | 3.2315             | AlMgSi1                 | ASTM 6351             | 100-200                   | 40xd1          | -              | 0.060       | 0.100             | 0.120            | 0.160             | 0.180                     | 0.200                 |       |       |   |       |       |       |       |       |       |
|   |  | 3.4365             | AlZnMgCu1.5             | ASTM 7075             |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   | Leghe d'alluminio pressofuse                           | 3.2163             | GD-AlSi9Cu3             | ASTM A380             | 80-150                    | 40xd1          | -              | 0.060       | 0.080             | 0.100            | 0.120             | 0.150                     | 0.180                 |       |       |   |       |       |       |       |       |       |
|   |  | 3.2381             | GD-AlSi10Mg             | UNS A03590            |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   | Rame   | 2.0040             | Cu-OF / CW008A          | UNS C10100            | 40-80                     | 2xd1           | 2xd1           | 0.065       | 0.080             | 0.110            | 0.130             | 0.160                     | 0.190                 |       |       |   |       |       |       |       |       |       |
|   |  | 2.0065             | Cu-ETP / CW004A         | UNS C11000            |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   | Ottoni senza piombo                                    | 2.0321             | CuZn37 CW508L           | UNS C27400            | 40-80                     | 2xd1           | 2xd1           | 0.065       | 0.080             | 0.110            | 0.130             | 0.160                     | 0.190                 |       |       |   |       |       |       |       |       |       |
|   |  | 2.0360             | CuZn40 CW509L           | UNS C28000            |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   | Ottoni, Bronzi<br>Rm < 400 N/mm <sup>2</sup>           | 2.0401             | CuZn39Pb3 / CW614N      | UNS C38500            | 50-120                    | 40xd1          | -              | 0.100       | 0.130             | 0.160            | 0.180             | 0.230                     | 0.250                 |       |       |   |       |       |       |       |       |       |
|   |  | 2.1020             | CuSn6                   | UNS C51900            |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| Bronzi<br>Rm < 600 N/mm <sup>2</sup>                                | 2.0966   | CuAl10Ni5Fe4       | UNS C63000              | 40-80                 | 40xd1                     | -              | 0.065          | 0.080       | 0.110             | 0.130            | 0.160             | 0.190                     |                       |       |       |   |       |       |       |       |       |       |
|   | 2.0960   | CuAl9Mn2           | UNS C63200              |                       |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| S <sub>1</sub>  | Super leghe  | 2.4856             |                         | Inconel 625           |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 2.4668             |                         | Inconel 718           |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 2.4617             | NiMo28                  | Hastelloy B-2         |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
|   |  | 2.4665             | NiCr22Fe18Mo            | Hastelloy X           |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| S <sub>2</sub>  | Titanio puro   | 3.7035             | Gr.2                    | ASTM B348 / F67       | 25-50                     | 3xd1           | 1xd1           | 0.030       | 0.040             | 0.055            | 0.070             | 0.080                     | 0.100                 |       |       |   |       |       |       |       |       |       |
|   |  | 3.7065             | Gr.4                    | ASTM B348 / F68       |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| S <sub>3</sub>  | Leghe di titanio                                       | 3.7165             | TiAl6V4                 | ASTM B348 / F136      | 20-40                     | 5xd1           | 1xd1           | 0.030       | 0.040             | 0.055            | 0.070             | 0.080                     | 0.100                 |       |       |   |       |       |       |       |       |       |
|   |  | 9.9367             | TiAl6Nb7                | ASTM F1295            |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |
| H <sub>1</sub>  | Acciai temprati < 55 HRC                               | 1.2510             | 100MnCrMoW4             | AISI O1               | 30-60                     | 5xd1           | 1xd1           | 0.050       | 0.060             | 0.080            | 0.100             | 0.120                     | 0.150                 |       |       |   |       |       |       |       |       |       |
|   |  | 1.2379             | X153CrMoV12             | AISI D2               |                           |                |                |             |                   |                  |                   |                           |                       |       |       |   |       |       |       |       |       |       |